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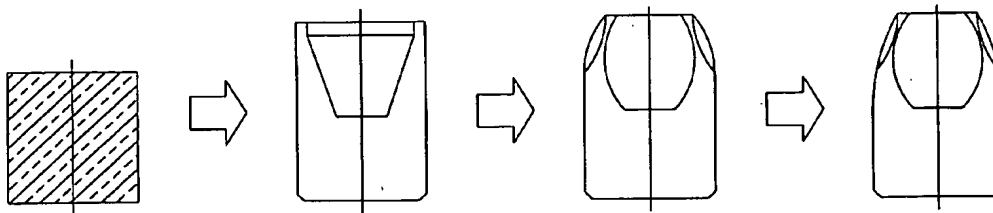
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(54) Title: **LEAD FREE MONOBLOC EXPANSION PROJECTILE AND MANUFACTURING PROCESS**



(57) Abstract: The present invention relates to a bullet made of a single solid piece of deformable metal, containing no lead or toxic material, easily deformable but without fragmentation in soft environment with a high rate of energy transfer, and a high level of solidity in hard targets, retaining most or its total initial weight while penetrating those targets. Said objects are achieved by constructing a solid monobloc bullet with a cavity on the longitudinal axis which is opened towards the fore end of the bullet. The method of construction encompasses a sequence of simple operations: cutting of a cylinder blank of soft material, forming a cavity centered on the longitudinal axis, and forming a ogival or conical form, with external pre-cuts to foster an homogenous deformation. The present invention applies to any handgun, rifle or shotgun ammunition; when used in smoothbores, the essential stability of the bullet is achieved by positioning the center of gravity ahead of the aerodynamic center.

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